

THE UNITED STATES PATENT AND TRADEMARK OFFICE
BEFORE THE BOARD OF PATENT APPEALS AND INTERFERENCES

In re Application of: Phyllis Liethem et al.

Serial No: 09/863,585

Filed: May 16, 2001

For: **ABSORBENT PRODUCTS AND METHODS OF PREPARATION
THEREOF**

Group Art Unit: 3761

Examiner : J. F. Stephens

RESPONSE TO NOTIFICATION OF NON-COMPLAINT
APPEAL BRIEF AND APPELLANTS' SUBSTITUTE SUPPLEMENTAL BRIEF

MAIL STOP APPEAL BRIEF - PATENTS

Commissioner for Patents

P.O. Box 1450

Alexandria, Virginia 22313-1450

Sir:

In communication mailed November 20, 2006, the Examiner found that an Appeal Brief allegedly filed on 1 April 2005 was defective because it did not "contain a concise explanation of the subject matter defined in claims involved in the appeal referring to the specification by page and line number and to the drawings, if any, by reference characters, (b) the brief fails to identify, for each independent claim involved in the appeal and for each dependent claim argued separately, every means plus function and step plus function under 35 U.S.C. 112, sixth paragraph, and/or (2) set forth the structure, material, or acts described in the specification as corresponding to each claimed function with references to the specification by page and line number, and to the drawings, if any, by reference characters. Appellants submit

this paper to explain why the Examiner's action is without merit and should be withdrawn and, in an abundance of caution, to conform their Brief to the requirements of 37 CFR 41.37, which Rule did not come into effect until after the Brief in question was filed.

I. Support for Withdrawal of the Notice of Non-Complaint Appeal Brief

1) Applicants Did Not File an Appeal Brief on 1 April 2005

The Notification of Non-Complaint Appeal Brief advises that an Appeal Brief filed on 1 April 2005 was defective under 37 CFR 41.37. However, Appellants did not file an Appeal Brief on this date. Rather, Appellants mailed a Request for Examiner's Answer on March 29, 2005 which was received on April 1, 2005. In this Request, Applicants noted that on August 18, 2004, they had filed a Request for Reinstatement of Appeal and a Supplemental Appellants' Brief which, despite several requests by telephone and letter, had not been acted on in more than seven (7) months.

2) Appellant's Supplemental Brief was filed by mail on August 18, 2004

Since no Appeal Brief was filed on 1 April 2005, Appellants assume that the Brief that the Examiner finds non-complaint under 37 CFR 41.37 is the Supplemental Appellants' Brief filed on August 18, 2004, 27 months prior to the issuance of the Notice of Non-Complaint Appeal Brief. The remainder of this response is based on this assumption.

3) The Rule Cited By Examiner Did Not Come Into Effect Until September 13, 2004

As indicated above, the last Appeal Brief filed by Applicant in this application was mailed on August 18, 2004. The Examiner's notice of Non-Complaint Appeal Brief cites to 37 CFR 41.37 which did not come into effect until September 13, 2004. Accordingly, the Rule in effect when the Brief in question was filed was 37 CFR 1.192. In the section of 1.192 which corresponds to §41.37 (c)(v) cited by the Examiner, namely 1.192(c)(5), it requires only that

Appellant should provide “a concise explanation of the invention defined in the class involved in the appeal, which shall refer to the specification by page and line number, and to the drawing, if any, by reference characters.”

In the present case, there is only one claim under appeal comprising of 4½ lines of text. It references only 3 elements of structure. The claim contains no “means plus function” or “step plus function” language. Further, the Summary of the Invention section of the Supplemental Brief filed on August 18, 2004 cites to the specification six (6) times. Accordingly, Appellants believe that the Appeal Brief filed on August 18, 2004 satisfied Rule 1.192, which was in effect at the time the Brief was filed.

4) Expediting Proceedings

Since this Appeal has been pending for over two years without an Examiner’s Answer, to expedite proceedings, Appellants’ counsel explained the forgoing to the Examiner during a telephone interview of the case with the Examiner after the issuance of the Notification of Non-Complaint Appeal Brief and prior to the filing of this paper. Appellants’ counsel was advised to file a written response.

5) Substitute Appeal Brief

In an effort to advance the prosecution of this appeal and to avoid further delay, Appellants’ hereinafter submit a revised Supplemental Appellants’ Brief which is believed to conform to the requirements of 37 CFR 41.37, notwithstanding that this Rule was not in effect when the underlying Appeal Brief was filed.

II. SUBSTITUTE SUPPLEMENTAL APPELLANTS' BRIEF

This is an appeal from the rejection of claim 104 in this application.

Appellants have previously paid the requisite fee for a Notice of Appeal and Appellants' Brief. Thus, it is believed that no new fee is due for filing this Supplemental Brief. If there is a fee due, then please charge any deficiency or credit any overpayment to Deposit Account 50-0540.

REAL PARTY IN INTEREST

The real party in interest in this appeal is Rayonier TRS Holding Inc. ("TRS"). TRS succeeded to the right of Rayonier Products and Financial Services Company ("RPFSC") upon the merger of RPFSC into TRS. RPFSC acquired the application from Rayonier Inc. by assignment. The referenced merger and assignment have not yet been recorded with the U.S. Patent & Trademark Office.

RELATED APPEALS AND INTERFERENCES

Appellants are not aware of any related appeals or interferences which directly affect, or are directly affected by, or have a bearing on the Board's decision in this appeal. However, Appellants have requested the declaration of an interference with U.S. Patent No. 6,063,982 upon the allowance of this application.

STATUS OF CLAIMS

Claim 104 is pending in this application. Claims 1-103 and Claims 105-150 have been cancelled.

Claim 104 stands rejected under 35 U.S.C. § 103(a) as allegedly obvious over U.S. Patent No. 3,658,064 to Pociluyko (hereinafter "**Pociluyko**") in view of U.S. Patent No. 2,083,575 to Novak (hereinafter "**Novak**").

Appendix A, annexed hereto, contains a copy of Claim 104.

STATUS OF AMENDMENTS

Appellants appeal the Office Action mailed June 25, 2004 rejecting Claim 104.

No amendment was filed subsequent to this Office Action. Thus, this appeal is directed solely to the claim 104 as reproduced in Appendix A.

SCHEDULE OF CITED PRIOR ART

Pociluyko (U.S. Patent No. 3,658,064) discloses an absorbent article, namely a disposable diaper, made with a pad of fluffed wood pulp (**Pociluyko**, Col. 4, lines 36-53).

Novak (U.S. Patent No. 2,083,575) teaches a process for making an absorbent felt like paper by wet laying pulp which has been treated with caustic soda. (**Novak** Col. 2, lines 14-28 and Col. 2, line 54 to Col. 3, line 20).

SUMMARY OF CLAIMED SUBJECT MATTER

Claim 104

The present invention relates to absorbent personal hygiene devices (3), such as for example diapers (3), which are comprised of an absorbent core (14) containing wood fiber pulp interposed between a water barrier sheet (16) and a layer that allows liquid (11) to pass through it. The wood fiber pulp used in the invention has been treated (extracted) using a caustic solution at relatively low temperature (below 60°C). Wood fiber pulp which is extracted with cold caustic is structurally different than conventional wood fiber pulp by reason of the removal of hemicellulose and lignin from the constituent cellulose fiber by the cold caustic treatment. (See U.S. Patent No. 3,932,209 to **Chatterjee**, Col. 4, lines 50-68, and compare Fig. 1 and Fig. 3 of **Chatterjee**; see also the Specification of this Application, page 4, lines 9-23). The cold caustic extracted wood fiber pulp used in the claimed product is in individualized fiber form (i.e.

fluffed). Individualized wood pulp fibers are formed by mechanical action of a hammermill mill, or other attrition device, prior to incorporation into the absorbent devices. The wood fiber pulp in the absorbent cores (14) of the invention is not chemically crosslinked. (Specification at page 1, lines 5-12, page 14, lines 10-22). The claimed absorbent core (14) contains at least about 25% of fluffed fiber pulp. (Specification at page 7, lines 16-19).

In the production of absorbent devices such as baby diapers, incontinence and catamenial devices and wound dressings (i.e. absorption intensive devices) which contain wood fiber pulp, it has been conventional to use chemical crosslinking to increase the stiffness of the wood fiber pulp fibers, so that a fiber matrix made from them retains its bulk and pore volume when wet, thereby enhancing its absorbency (Specification at page 2, line 16 to page 3, line 10; and **Chatterjee**, Co. 1, lines 35-40).

Prior to the present invention, it was not believed to be possible to achieve the absorption, insult (or re-wetting), liquid retention, softness and pad integrity of modern absorbent personal hygiene devices without employing chemically crosslinked wood fiber pulp. Chemically crosslinked wood pulp fiber has increased the wet stiffness which prevents wet fiber collapse, thereby enhancing absorbency. (Specification, page 3, lines 3-9). The Specification of the present application at page 2, lines 16 to 22 references several prior patents directed to the use of chemically crosslinked wood fiber pulp in absorbent personal hygiene articles. The previously cited art of record, **Chatterjee**, is another such example. The present invention surprisingly discovered that by employing wood fiber pulp according to the invention, an absorbent core with desirable absorbency properties for use in personal hygiene devices could be formed without chemically crosslinked wood fiber pulp. The avoidance of chemically

crosslinked wood fiber pulp was the expressed objective of the present invention (Specification at page 1, lines 6-12).

The present invention is commercially important in that it enables the manufacture of absorbent articles containing wood fiber pulp without the expense of using chemically crosslinked wood fiber pulp. The same invention has already been patented to a third party in U.S. Patent No. 6,063,982 with which Appellants have requested that an interference be declared. Applicants' Request for Interference was filed in this application on August 27, 2001.

GROUND OF REJECTION

The issue on appeal is whether Claim 104 is patentable under 35 U.S.C. §103(a) over **Pociluyko** in view of **Novak**.

GROUPING OF CLAIMS

Only Claim 104 is pending. Thus, no grouping of claims is necessary.

ARGUMENT

Claim 104 is patentable under 35 U.S.C. §103(a) over Pociluyko in view of Novak.

The Examiner has rejected claim 104 under 35 U.S.C. 103(a) as being unpatentable over Pociluyko (USPN 3,658,064) in view of Novak (USPN 2,083,575). The Examiner stated that Pociluyko discloses an absorbent article comprising a fluid permeable topsheet layer, a substantially fluid impermeable backsheet layer and a sublayer of fluff material. The Examiner conceded that Pociluyko does not disclose the method of manufacturing his fluff material, and does not suggest that Pociluyko discloses the use of cold caustic (base) treated pulp in his absorbent articles. Rather, the Examiner states that Novak discloses a method of making fluff pulp capable of being used in personal hygiene articles which comprises treating a wood

fiber pulp containing wood fibers with a base at room temperature. Therefore, the Examiner concluded that the present invention is obvious over the combination of these two references.

The present invention relates to absorbent composites comprised of cold caustic (a base) extracted wood fiber pulp which then is fluffed prior to being interposed between a fluid permeable top sheet and an impermeable bottom sheet.

Applicants submit that the Examiner has not established a *prima facie* case of obviousness. To establish a *prima facie* case of obviousness, there must be some suggestion or motivation, either in the references themselves or in the knowledge generally available to one of ordinary skill in the art, to modify the reference or to combine reference teachings. In addition, there must be a reasonable expectation of success. The teaching or suggestion to make the claimed combination and the reasonable expectation of success must both be found in the prior art, not in applicant's disclosure, MPEP 2143; *In re Vaeck*, 947 F.2d 488, 20 USPQ2d 1438 (Fed. Cir. 1991).

The Examiner's reliance upon the combination of Pociluyko and Novak to arrive at the present invention is misplaced because neither Pociluyko nor Novak suggest that the Novak pulp would be suitable for use in the claimed absorbent composites. Further, Novak does **not** teach that his pulp is fluffed. The pulp product of Novak is a wet-laid felt and not a fluff material as the Examiner has alleged. As explained in the present Specification at page 14, lines 10-23, to fluff a wood fiber pulp, it must first be dried and then subjected to dry shredding in a Hammermill or other attrition mill. The **Chatterjee** reference, which was previously cited by the Examiner, describes the same procedure for making wood pulp fluff at **Chatterjee**, column 6, lines 18-34. In contrast, **Novak** describes introducing sheets of pulp into a Holland beater "with sufficient water to allow the stock to properly circulate." After the stock of **Novak** is separated,

it is dumped into a stock chest and run off on a paper machine in the usual manner to make felt-like paper. See **Novak**, col. 2, line 54 to col. 3, line 16. Accordingly, **Novak** clearly describes the manufacture of wet-laid paper, not dry shredded fluff.

Those skilled in the art could not substitute the felt of Novak for the fluff material of Pociluyko to produce the presently claimed invention as the Examiner has concluded, even if they did the resultant composite would not contain “fluffed wood fiber pulp” as claimed. Further, since the teachings of Pociluyko and Novak were known to those skilled in the art for more than 30 and 70 years, respectively, before the present invention, even if Novak taught fluffed pulp, it is improper for the Examiner to conclude without benefit of suggestion in the cited art that a person skilled in the art would find it obvious to combine these two references to arrive at an absorbent composite which does not require chemically crosslinked pulp. If the invention were obvious as the Examiner has concluded, it would not have taken 70 years for Novak’s caustic extracted pulp felt to be fluffed and incorporated in the presently claimed absorbent composite.

Accordingly, Applicants submit that the Examiner’s §103 rejection is improper because 1) Novak does not disclose a fluffed pulp as the Examiner has alleged; 2) the combination of references relied upon is not suggested by the prior art, as is required; 3) even if the Examiner’s combination were to be suggested, it would not yield the presently claimed combination, and 4) the prior art previously relied upon (**Chatterjee**) teaches away from the use of pulp which is not chemically crosslinked.


CONCLUSION

For the foregoing reasons, it is submitted that the presently pending claim 104 is allowable and the rejection of Claim 104 is improper and should be reversed. Allowance of Claim 104 is in order and such action is solicited.

Dated: December 20, 2006

Respectfully submitted,

By:



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Appendix A - Claims

Claim 104.

An absorbent personal hygiene device comprising: a layer that allows liquid to pass, a water barrier sheet, an absorbent core interposed between said layer and said sheet, the absorbent core containing at least about 25% of fluffed wood fiber pulp, wherein said fluffed wood fiber pulp comprises wood fiber pulp that has been cold caustic extracted and fluffed by mechanical action and is without chemical crosslinking.

Appendix B – Evidence

US Patent No. 3,932,209 to Chatterjee – cited by the Examiner in the Official Action and PTO-892 mailed on September 19, 2002.

[54] **LOW HEMICELLULOSE, DRY
CROSSLINKED CELLULOSIC ABSORBENT
MATERIALS**

[75] Inventor: **Pronoy Kumar Chatterjee,**
Spotswood, N.J.

[73] Assignee: **Personal Products Company,**
Milltown, N.J.

[22] Filed: **Aug. 9, 1971**

[21] Appl. No.: **169,957**

Related U.S. Application Data

[62] Division of Ser. No. 803,525, Feb. 24, 1969,
abandoned.

[52] U.S. Cl. **162/157 C; 8/116.2; 162/146**

[51] Int. Cl.² **D21H 5/14**

[58] Field of Search **162/146, 157 C; 8/116.2,**
8/116.4, 116 R

References Cited

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3,224,926	12/1965	Bernardin 162/146	
3,339,550	9/1967	Van Haaften 128/290 R	
3,395,708	8/1968	Hervey et al. 162/179 X	
3,440,135	4/1969	Chung 162/157 C	
3,485,575	12/1969	Christian et al. 8/116.2	
3,535,202	10/1970	Huang 162/166	

FOREIGN PATENTS OR APPLICATIONS

1,095,505 12/1967 United Kingdom

Primary Examiner—Robert L. Lindsay, Jr.

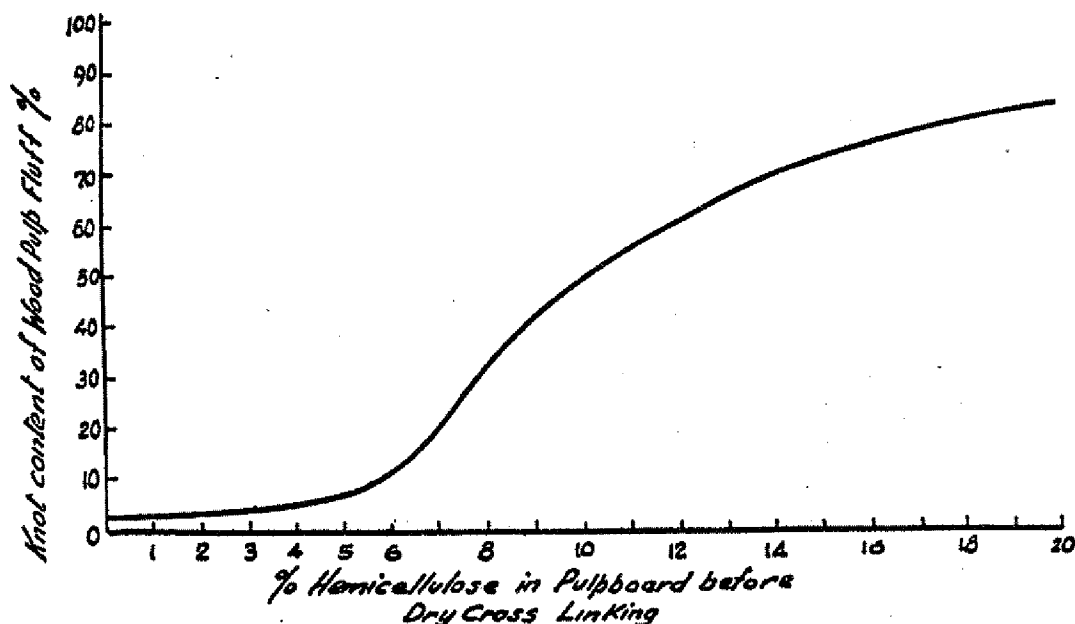
Assistant Examiner—William F. Smith

Attorney, Agent, or Firm—Jason Lipow

[57] **ABSTRACT**

Dry crosslinked, fibrous cellulosic absorbent material having low hemicellulose content and low knot content, the fibers being internally crosslinked for the major part and being relatively free of intercrosslinking with adjacent fibers.

3 Claims, 9 Drawing Figures



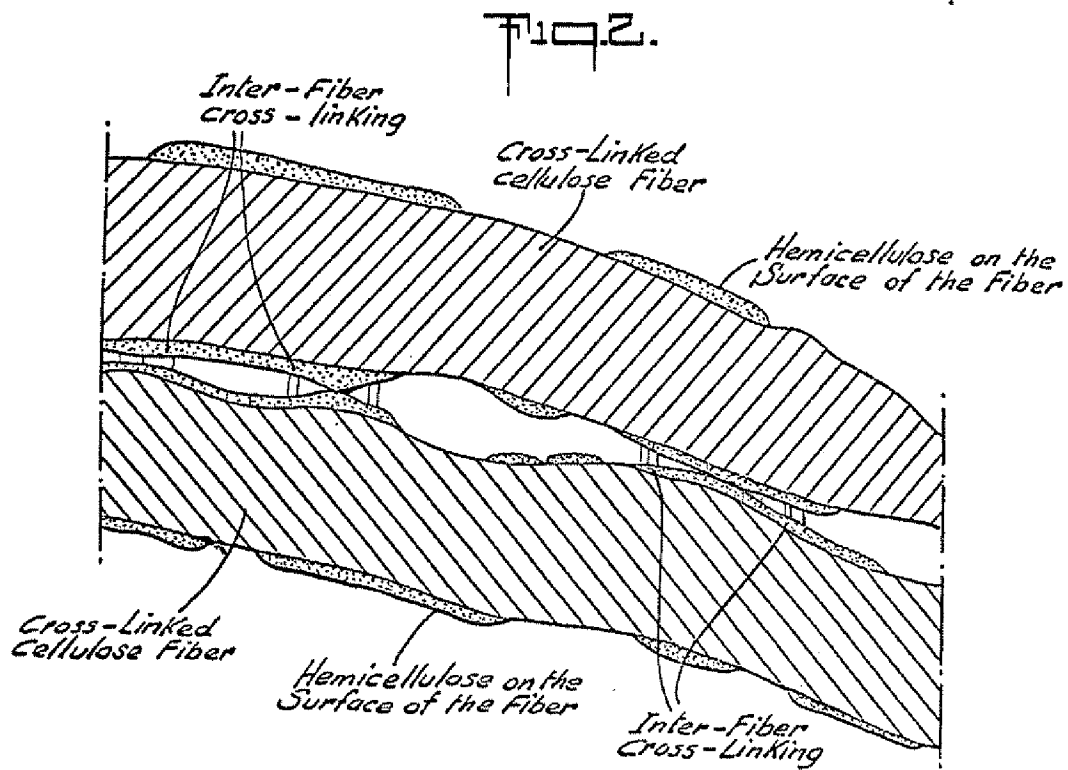
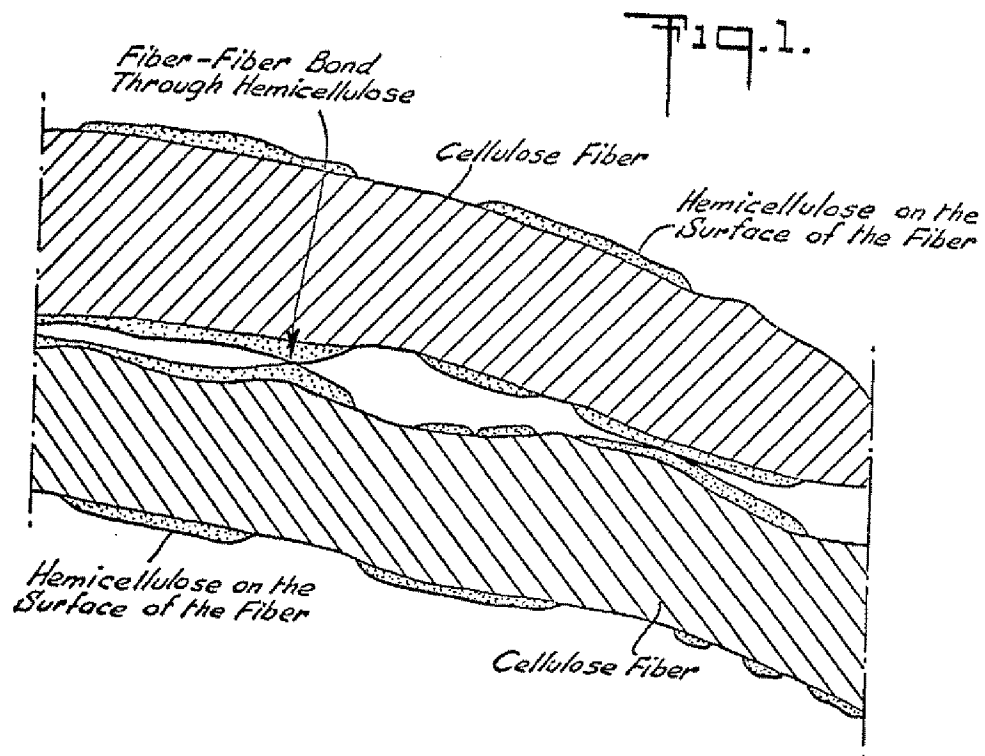


Fig. 3.

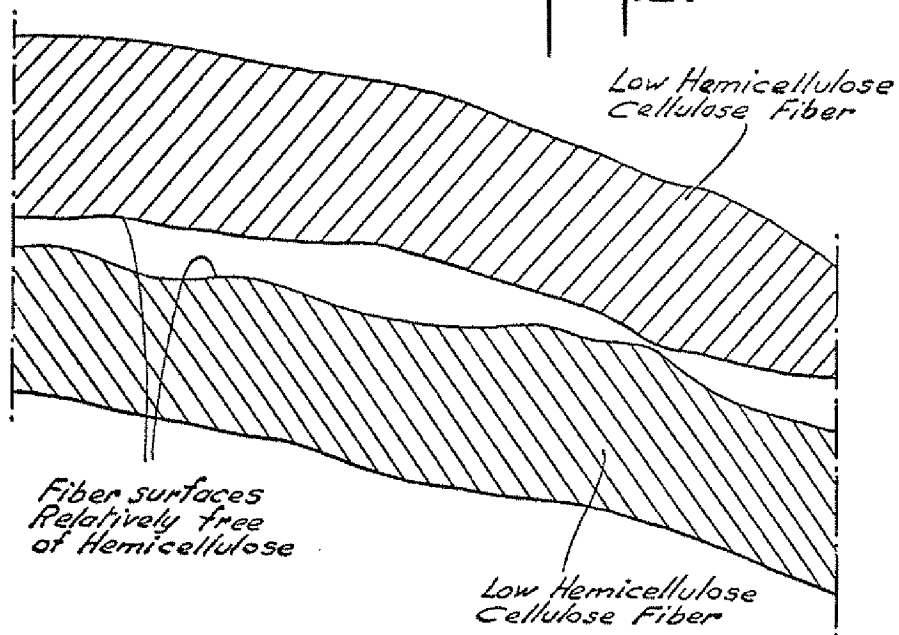


Fig. 4.

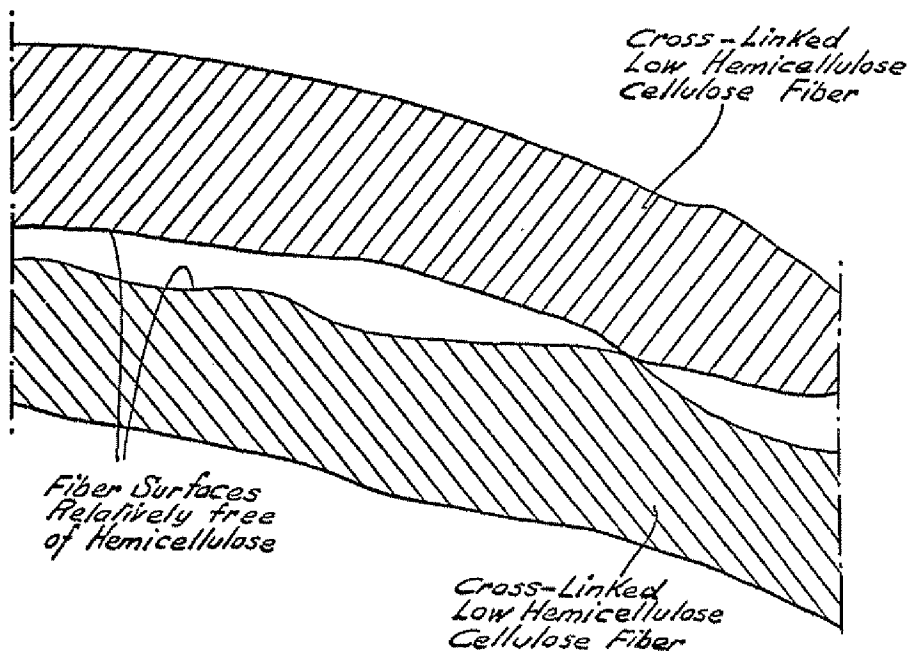


Fig. 5.

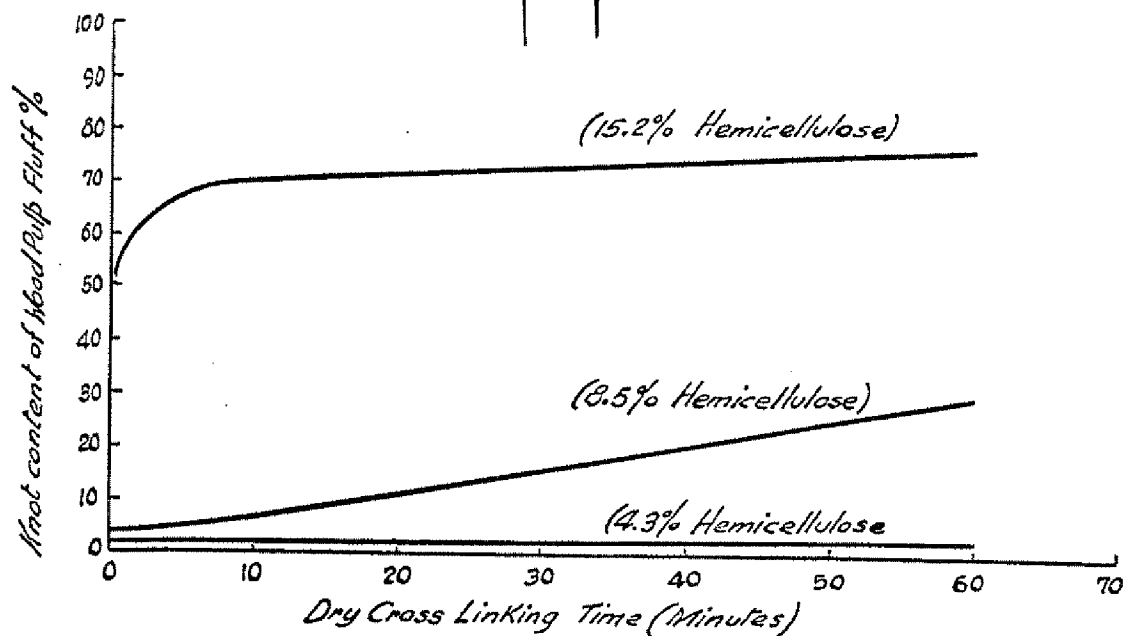


Fig. 6.

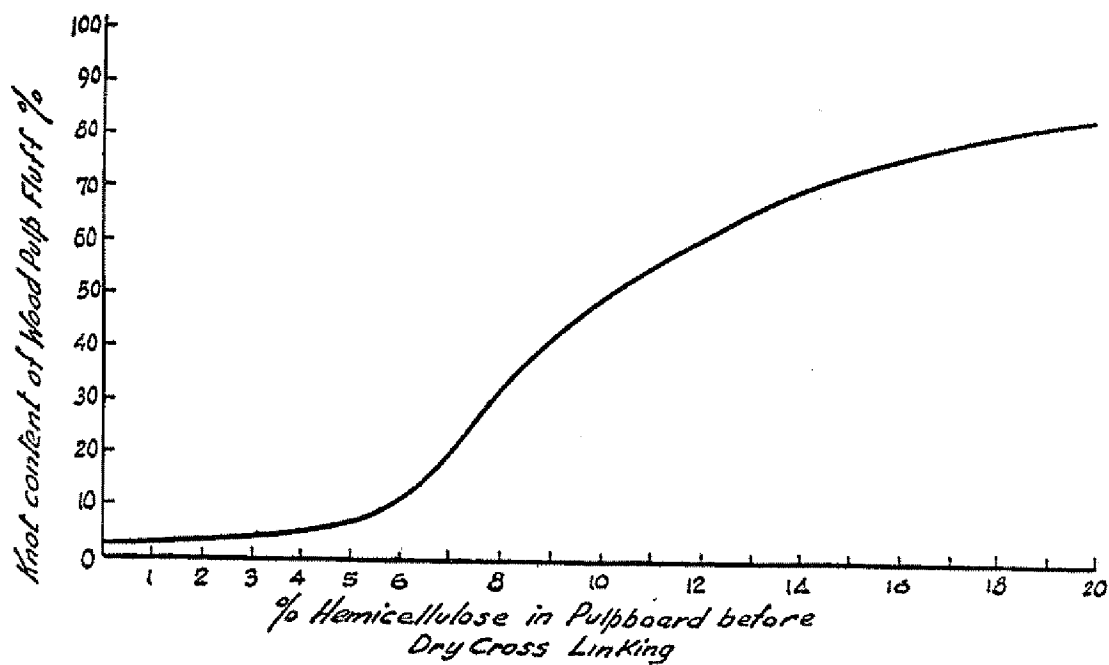


Fig. 7.

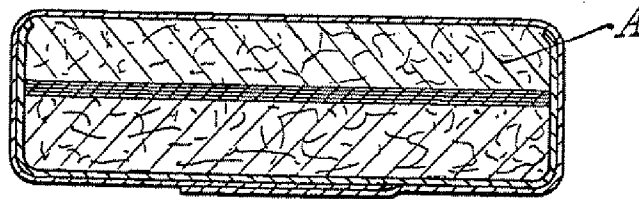


Fig. 8.

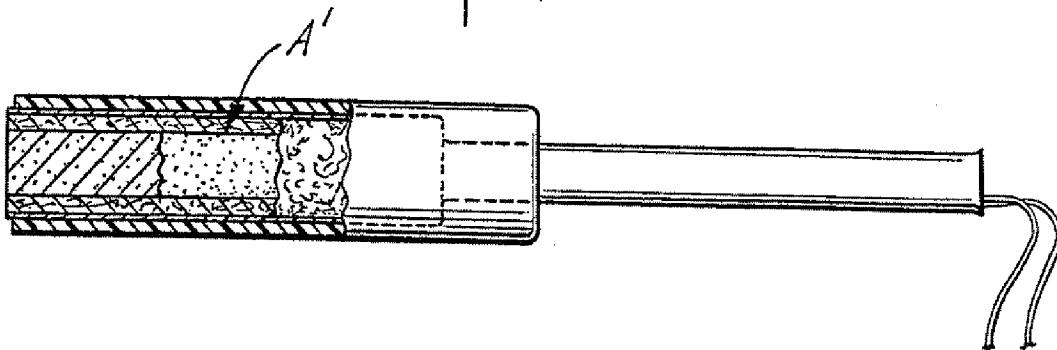
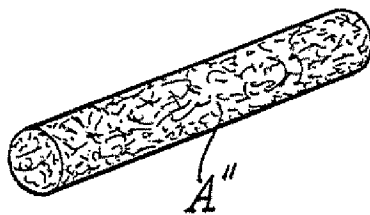


Fig. 9.



LOW HEMICELLULOSE, DRY CROSSLINKED CELLULOSIC ABSORBENT MATERIALS

This is a divisional application of U.S. patent application Ser. No. 803,525, filed Feb. 24, 1969, now abandoned.

The present invention relates to absorbent products for absorbing fluids, and more particularly, is concerned with fibrous cellulosic products having increased fluid absorption and retention capacities, improved dry and wet resilience, and low knot content.

Absorbent products for absorbing and retaining body exudates and fluids such as sanitary napkins, diapers, hospital underpads, filter pads, surgical dressings, tampons, and the like, usually contain fibrous absorbent materials of a cellulosic origin, usually wood pulp fluff. Other fibrous absorbent materials are often used but wood pulp fluff is normally preferred, particularly for economic reasons.

The wood pulp fluff is usually prepared by grinding pulpboard in a hammer mill or in other commercial shredding or grinding devices and is delivered in fluffed form to a production line where it is incorporated in the particular product being manufactured. Such wood pulp fluff normally has excellent fluid absorption and retention properties and acceptable dry and wet resilience. Its low cost and other economic advantages, of course, do not need repeating.

Wood pulp fluff has been used for many years with satisfactory results but it is always desirable to improve existing products and materials, no matter how satisfactory or acceptable they have been in the past.

For example, in recent years, there have been several efforts made in the direction of crosslinking cellulosic fibrous materials such as wood pulp fluff in order to improve their fluid-absorbency and fluid-retention properties, along with their dry and wet resilience.

Crosslinking cellulosic fibers may be obtained by reacting cellulosic fibers with a material one or more molecules of which are capable of combining with at least two hydroxyl groups in the cellulose molecule, or in adjacent cellulose molecules. The reactive groups of the crosslinking agent which combine with the hydroxyl groups may exist prior to the reaction with cellulose, as in the case of glyoxal, or they may be generated during the reaction with the cellulose, as in the case of the sodium thiosulfate derivative of divinyl sulfone. In order to crosslink cellulose, the crosslinking agent must be at least difunctional with respect to cellulose, e.g., it must react with at least two hydroxyl groups. Formaldehyde, for example, is monofunctional with regard to many substances; it is, however, difunctional with respect to cellulose. In many polyfunctional materials of the type that react with two or more hydroxyl groups, one reactive group of the polyfunctional material may react more rapidly than other groups. Consequently, within a given reaction time, not all of the reactive groups on a molecule of the polyfunctional material may react with the hydroxyl groups in the cellulose molecule to form crosslinks; only one of the reactive groups may so react. Crosslinking occurs when at least two of the reactive groups in a molecule of the polyfunctional material react.

Cellulose can be crosslinked in a number of ways and, in accordance with current concepts, may be dry crosslinked or wet crosslinked. The two types of cross-

linking refer to the manner in which the crosslinking is done.

Dry crosslinked cellulose is obtained when the cellulose is in a collapsed state at the time of crosslinking. A collapsed state is obtained by removing most or all of the water which causes the fiber to swell. In one known procedure, the cellulose is passed through a boric acid solution, dried, and then heated in a sealed tube in the presence of paraformaldehyde. The fibers are then washed free of unreacted material. A more common technique is to apply the crosslinking agent and a catalyst to the cellulose in an aqueous bath, drive off the water in a drying step, and react the crosslinking agent with the cellulose in a subsequent curing step.

Wet crosslinked cellulose is obtained when the crosslinking agent is reacted with the cellulose while the cellulose is in a swollen state. Ordinarily, the cellulose is maintained in a swollen state by water which is present during the reaction. However, techniques have been developed whereby the cellulose can be maintained in a swollen state in the absence of water by using in lieu thereof an inert, non-volatile substance. Cellulose fibers so treated have the properties of wet crosslinked cellulose even though the reaction takes place in the absence of significant amounts of water.

The present invention will be described in greater particularity in combination with the dry crosslinking reaction wherein the fibers are not swollen but are collapsed. The invention will be disclosed specifically with reference to the use of formaldehyde as the dry crosslinking agent. This, however, is for purposes of illustration and it is to be appreciated that other dry crosslinking agents can be used. Additional dry crosslinking agents, for example, include: condensation products of formaldehyde with organic compounds such as urea, thiourea, guanidine, or melamine, which contain at least two active hydrogen groups, particularly dimethylolurea and dimethylol ethyleneurea; dicarboxylic acids; dialdehydes; diepoxides; diisocyanates; divinyl compounds; etc.

The most convenient method of carrying out such a dry crosslinking reaction is naturally on the pulpboard itself at which time it is compact and easy to handle, large chambers are not required for curing the product in a large scale production operation, and large ovens would not be required for drying and controlling the moisture content of the product.

Unfortunately, it has been found that such a process of dry crosslinking pulpboard creates considerable problems in the subsequent shredding or grinding step and an unsatisfactory wood pulp fluff is obtained which was not disintegrated properly during the grinding process and which contains severe fiber breakage in the final product. Another important objection is the very high knot content of the wood pulp fluff and the hard fiber clumps or knots which are present sometimes rise as high as about 50-75% and render the product completely unsuitable for many purposes.

In order to avoid such shortcomings, it has been proposed that the pulpboard be difibered first and that the resulting fibrous product be in a substantially individually or loosely associated state and have a multiplicity of relatively large interconnected networks of voids and interfiber spaces at the time of the subsequent crosslinking reaction. In this way, it was hoped that the formation of hard fiber clumps and knots would be avoided. Unfortunately, the additional costs and economic disadvantages of such a system were too

great and the search has continued for a better process and a better product.

It is therefore a purpose and object of the present invention to provide a method of dry crosslinking the pulpboard itself in such a way that the pulpboard can be subsequently ground to yield a wood pulp fluff having a very low hard fiber clump or knot content, along with increased fluid absorption and retention capacities, and improved dry and wet resilience.

It has been discovered that such purpose and object may be accomplished by pretreating the commercial pulp before the pulpboard is formed in such a way as to remove or to at least decrease the hemicellulose content thereof below certain minimums whereby the pulpboard made therefrom can be subsequently dry crosslinked and its properties improved without materially increasing the knot content.

The invention will be described in greater detail by reference to the following specification and accompanying drawings wherein there is described and illustrated preferred embodiments of the present invention for disclosure purposes but not for limitative purposes. With reference to the accompanying drawings,

FIG. 1 is an idealized drawing, greatly magnified, of two adjacent cellulose fibers, as they are in conventional pulpboard.

FIG. 2 is an idealized drawing, greatly magnified, of two adjacent cellulose fibers of a conventional pulpboard which has been crosslinked, without the pretreatment of the present invention to remove hemicellulose.

FIG. 3 is an idealized drawing, greatly magnified, of two adjacent cellulose fibers of a pulpboard prepared from cellulose fibers pretreated to remove hemicellulose.

FIG. 4 is an idealized drawing, greatly magnified, of two adjacent cellulose fibers of a pulpboard which has been crosslinked, after being given the pretreatment of the present invention to remove hemicellulose.

FIG. 5 is a graph showing the relationship between the increase in dry crosslinking time to the change in knot content of wood pulp fluff derived from three sources and having three different percentages of hemicellulose content.

FIG. 6 is a graph showing the relationship between the percent of hemicellulose in the pulpboard before crosslinking and the knot content (percent) in the wood pulp fluff after grinding.

FIG. 7 is a cross-sectional view of a sanitary napkin incorporating the dry crosslinked, low hemicellulose content, low knot content fibrous absorbent materials A of the present invention.

FIG. 8 is a plan view, partially cut away, of a catamenial tampon incorporating the dry crosslinked, low hemicellulose content, low knot content fibrous absorbent materials A' of the present invention.

FIG. 9 is a perspective view of a dental roll incorporating the dry crosslinked, low hemicellulose content, low knot content fibrous absorbent materials A'' of the present invention.

With reference to FIG. 1, there are shown two cellulose fibers having a normal cellulosic structure which, if derived from a softwood, originally had as its major constituents about 40-45% cellulose, 25-30% hemicelluloses, and 25-30% lignin. If derived from a hardwood, the major constituents would change slightly percentagewise to about 45-50% cellulose, 25-35% hemicelluloses, and 20-25% lignin.

During the technical pulping process which is often described as a chemical cooking of wood or a delignification, the majority of the lignin or lignin-like materials are removed, although small amounts thereof still remain and are incorporated into the pulpboard. Also remaining in the pulpboard are varying amounts of hemicelluloses. It is known that considerable amounts of hemicelluloses remain in the fibers after the pulping process, and even after the final bleaching process. As a result, pulpboard having a hemicellulose content of as high as about 15.2% or even higher, is known and will be referred to in greater detail hereinafter.

Hemicelluloses are a group of gummy, amorphous substances intermediate in composition between cellulose and the sugars. They accompany cellulose in the plant cell wall and consist mainly of xylan, mannan, glucomannan, araban, galactan, arabogalactan, uronic acids, plant gums, and related polymers containing residues of L-rhamnose. They are more swellable than cellulose fibers because of their amorphous structure and because of their lower Degree of Polymerization which is believed to be no greater than about 150. A considerable amount of these hemicelluloses are distributed on the surfaces of conventional cellulose fibers, as illustrated in FIG. 1, and may either actually contact each other, or be very close to each other by distances on the order of only a few Angstroms. As a result of this, they help to form good bonding between adjacent fibers during the pulpboard manufacturing process.

During the crosslinking process which is intended to form crosslinks within the individual cellulose fibers and enhance their absorbent properties, there is also a considerable amount of crosslinking taking place between closely adjacent cellulose fibers, as shown in FIG. 2. This intercrosslinking between fibers easily takes place in the presence of the hemicelluloses preferentially to the amount of intracrosslinking which takes place within the cellulose fiber for many reasons, primarily because of the amorphous structure of the hemicelluloses and their close proximity.

Such intercrosslinking between adjacent cellulose fibers whereby they are chemically and physically adhered is naturally conducive to the formation of knots or clumps of cellulose fibers which prevents proper disintegration of the pulpboard during grinding and leads to highly undesirable high knot contents in the resultant wood pulp fluff.

However, if the hemicellulose is removed during the commercial pulping process, along with the lignin, or if it is removed by a separate alkali treatment after the lignin is removed, or if it is removed at any time prior to the crosslinking reaction, or at least has its content reduced sufficiently, as shown in FIG. 3, then there is very little tendency toward subsequent intercrosslinking between adjacent cellulose fibers, as shown in FIG. 4. The result is a lesser tendency to form knots or clumps of cellulose fibers and a resultant wood pulp fluff with very low knot content.

The hemicelluloses may be removed by any desired pretreatment at any time prior to the crosslinking step. For example, they may be preferentially extracted in substantial amounts or in their entirety by using aqueous solutions of from about 5 to about 12% of a "cold" caustic at temperatures ranging from about 15° to about 35°C. as an additional refining step during the pulping process.

It is not necessary that all of the hemicelluloses be removed completely. Such, of course, will normally yield the best product. However, such complete removal is uneconomical unless the requirements of a specific product are sufficiently demanding as to require it.

Within the more normal commercial requirements such as uses in absorbent products such as sanitary napkins, diapers, hospital underpads, filter pads, surgical dressings, tampons, and the like, a knot content in the wood pulp fluff of below about 12%, after a 60-minute formaldehyde dry crosslinking, as described herein, is deemed acceptable. A knot content of about 15% would be considered marginal but still acceptable for the above-mentioned products.

Reference to FIG. 6 reveals that under normal circumstances, if one were to start with a pulpboard having a hemicellulose content of about 7% or under, and dry crosslink that pulpboard by means of formaldehyde for about 60 minutes, as described herein, then the knot content of the wood pulp fluff derived from grinding that pulpboard, as described herein, is in the average range of about 15% or less and is suitable for the purposes of the present invention. As used herein, therefore, the term "low hemicellulose content" will include pulpboard containing about 7% hemicellulose or less. Reference to FIG. 6 will also indicate that a pulpboard having a hemicellulose content of about 6% will normally yield, after dry crosslinking and grinding, a wood pulp fluff having an average knot content of about 12%.

The invention will be described in greater particularity by reference to the following examples which are used for illustrative purposes and are not to be construed as limitative of the broader aspects of the present invention, except as set forth in the appended claims.

Although these examples are carried out with a southern pine kraft pulp, it is to be appreciated that such is merely for illustrative purposes and that the principles of the present invention are equally applicable to pulps derived from any of the presently known processes, or combinations thereof. Examples of pulps derived from known processes are: sulfite pulps in which the cooking liquor, calcium bisulfite, is acid, or sodium sulfite which is neutral or slightly alkaline; soda pulps in which the cooking liquor, caustic soda, is alkaline; sulfate pulps in which the cooking liquor, sodium hydroxide and sodium sulfide, is alkaline; etc. Semi-chemical, mechanical, and groundwood pulps are also of use.

EXAMPLE I

Three samples of pulpboard (southern pine, kraft pulp) which are differentially treated with caustic during the pulping process to remove different amounts of hemicelluloses are prepared to the following specifications (Table I):

TABLE I

Hemicellulose content	1	2	3
Pulpboard density (g./cc.)	Low	Medium	High
Fiber Classification:	0.58	0.58	0.58
Screen size 20	69.1	73.9	57.8
Screen size 35	15.3	12.9	29.0
Screen size 65	8.8	5.4	5.8
Screen size 150	2.8	1.6	1.6
Fines	4.3	8.5	15.2
α -cellulose	95.7	91.5	84.8

TABLE I-continued

Hemicellulose content	1	2	3
Pulpboard density (g./cc.)	Low	Medium	High
Fiber Classification:	0.58	0.58	0.58
Hemicelluloses	4.3	8.5	15.2

These samples are crosslinked by being immersed in a solution containing by volume 10% Formalin (37% formaldehyde), 9% hydrochloric acid (36% HCl), and 81% glacial acetic acid. Separate samples are maintained in the crosslinking solution at room temperature for 5 minutes, 15 minutes, and 60 minutes, then immersed in a series of solutions of 5% sodium bicarbonate until neutralization is complete, then rinsed in running water, and finally air dried at room temperature. Control samples are used for comparison purposes and are merely washed in running water without any crosslinking treatment and then are air dried. The formaldehyde add-on is noted in Table 2.

TABLE 2

Hemicellulose Content	1	2	3
Formaldehyde add-on	Low	Medium	High
(Percent) (5 minutes)	0.283	0.280	0.314
(15 minutes)	0.517	0.474	—
(60 minutes)	1.306	1.124	0.858

The grinding of the various samples of pulpboard is carried out in a Weber hammer mill and the knot content of the resulting wood pulp fluff samples is determined according to the constant air-blowing technique. This involves placing a 5 gram sample in the bottom of a 1000 ml. burette and admitting air through the petcock at the bottom at a controlled constant flow rate of 3.5 cubic feet per minute to get a tumbling action of the sample, thereby causing the individualized fibers of the sample to escape through the open top end of the burette but leaving the heavier knots or clumps at the bottom. The knots are then removed and weighed and the knot content (percent) determined (Table 3).

TABLE 3

Sample	percent of Sample Remaining	1	2	3
Hemicellulose content	Low	Medium	High	
No crosslinking	2	2	51	
5 minutes crosslinking	2	4	76	
15 minutes crosslinking	3	9	76	
60 minutes crosslinking	3	37	75	

These results are set forth in FIG. 5 of the drawings. It is quite apparent that crosslinking had no material effect on the knot content of sample 1 (4.3% hemicelluloses). This sample had a knot content of 3% after 60 minutes of formaldehyde crosslinking and is suitable for use as an absorbent in a sanitary napkin. However, crosslinking has serious effects on samples 2 and 3 (8.5% hemicellulose and 15.2% hemicellulose, respectively) and neither sample is suitable for use as an absorbent in a sanitary napkin. The knot content of wood pulp fluff derived from these latter samples are noted as 37% and 75%, after a 60-minute formaldehyde crosslinking treatment. These values are noted in FIG. 6.

EXAMPLE II

The procedures of Example I are followed substantially as set forth therein except that a ground Natchez pulp (southern pine, kraft pulp) is used. The hemicellulose content of the pulpboard is about 9%. A control sample which is not crosslinked is used and develops a knot content of 14% in the groundwood pulp fluff which would be marginally acceptable for many absorbent products. After dry crosslinking another sample (also 9% hemicellulose) by formaldehyde for 60 minutes as described previously, and grinding in a Weber mill, the knot content of the groundwood pulp fluff is determined to be 45% which renders it unsatisfactory for most absorbent purposes.

EXAMPLE III

Additional 0.5 gram samples of pulpboard No. 1 (4.3% hemicellulose) and pulpboard No. 2 (8.5% hemicellulose) prepared as set forth in Example I and conditioned at 72°F. and 65% relative humidity are used to determine wet bulk volume and absorbent capacity (water).

TABLE 4

Sample No. 1	Density gms./cc.	Wet Bulk Volume cc./gm.	Absorbent Capacity cc./gm.
(Control)	0.034	16.24	14.72
(Crosslinked, 60 mins.)	0.035	19.18	17.85

It is to be noted (Table 4) that in this sample containing low hemicellulose content of only 4.3%, the density did not change materially and that the wet bulk volume increased 18% and the absorbent capacity increased 21% which is excellent.

TABLE 5

Sample No. 2	Density gms./cc.	Wet Bulk Volume cc./gm.	Absorbent Capacity cc./gm.
(Control)	0.035	16.35	15.24
(Crosslinked, 60 mins.)	0.049	17.15	15.74

It is to be noted (Table 5) that in this sample containing higher hemicellulose content of 8.5%, the density increased markedly and the wet bulk volume increased only 4.9% and the absorbent capacity increased only 3.3% which is not significant. The deleterious effects of the hemicellulose on the properties of wet bulk volume and absorbent capacity is clearly demonstrated.

EXAMPLE IV

For determining the dry and wet resilience of the low hemicellulose fibers, similar samples are prepared as in Example III. For determining the dry resilience, samples are conditioned at 72°F. and 65% relative humidity. For determining the wet resilience, samples are placed in petridishes containing sufficient water to saturate the samples which are permitted to remain there for several minutes before testing begins.

The dry control sample (hemicellulose content =4.3), upon application of 200 grams/cm.² pressure, compressed to 12% of its original bulk volume, and recovered to 31% of its original bulk volume upon removal of the pressure. The dry resilience is therefore 31%.

The wet control sample (also hemicellulose content=4.3) collapsed to 55% of its original bulk volume upon being wetted, then compressed to 10% of its original bulk volume upon application of 200 grams/cm.², and recovered to 23% of its original bulk volume upon removal of the pressure. The wet resilience is 41%.

The dry crosslinked sample (hemicellulose content =4.3), upon application of 200 grams/cm.² pressure, compressed to 42% of its original bulk volume, and recovered to 59% of its original bulk volume upon removal of pressure. The dry resilience is 59% which is a very great improvement over the dry resilience of 31% of the uncrosslinked control sample.

The wet crosslinked sample (also hemicellulose content =4.3) collapsed to 67% of its original bulk volume upon being wetted, then compressed to 14% of its original bulk volume upon application of 200 grams/cm.², and recovered to 31% of its original bulk volume upon removal of the pressure. The wet resilience is 47% which is an improvement over the wet resilience of 41% of the control uncrosslinked sample.

The improvement in dry and wet resilience due to crosslinking is evident from the results of this example.

EXAMPLE V

Additional samples of pulpboard 1 and pulpboard 2, as described in Example I, are ground in a commercial Fitzpatrick hammer mill rather than a Weber hammer mill to determine the effect, if any, of the use of a different grinding mill.

Pulpboard sample 1, having a low hemicellulose content of about 4.3 percent is ground in a commercial Fitzpatrick hammer mill without any prior treatment of any kind. The knot content is determined to be about 12%. A control pulpboard sample, treated with a running water wash and air drying (no crosslinking) is similarly ground and the knot content is determined to be about 10 percent. When exposed to a 60-minute dry crosslinking by formaldehyde, and then ground similarly, the knot content is determined to be only 8 percent. This ground product is acceptable for the purposes of the present invention.

Pulpboard sample 2, having a higher hemicellulose content of about 8.5 percent is similarly tested and the knot contents are determined to be 21 percent, 19 percent, and 57 percent, respectively. This ground product is unacceptable for the purposes of the present invention.

The desirability of a lower hemicellulose content in the pulpboard is thus illustrated again.

Although the present invention has been described with particular reference to the preceding examples and in the specification to cellulose fibers derived from wood, it is to be appreciated that the principles are equally applicable to other cellulosic fibrous materials which also contain sufficient hemicelluloses as to interfere with a subsequent crosslinking process. Examples of such other fibrous materials include esparto grass, straw, and the like, as well as industrial waste products such as cotton seed hulls, corn cobs, corn stalks, peanut shells, etc.

It is not necessary that the de-hemicellulosed, cross-linked cellulose fibers be used as the sole constituent of the absorbent portion of the product involved. It may be blended, if desired, in proportions as low as 10% by weight up to 90% with other fibers or other fibrous materials, depending upon the requirements of the particular product. Such other fibers and other fibrous

materials include cotton fibers, cotton linters, rayon, wood pulp, cotton batting, synthetic fibers, such as cellulose esters notably cellulose acetate, polyesters from dihydric alcohols and terephthalic acid such as "Dacron" and "Kodel", acrylics containing at least 85% by weight of acrylonitrile such as "Acrilan" and "Orlon", modacrylics containing less than 85% but at least 35% of acrylonitrile such as "Dynel" and "Verel", polyamides such as nylon 6 and nylon 6/6, polyolefins such as polyethylene and polypropylene, spandex fibers derived from polyurethane such as "Lycra" and "Vyrene", fluorocarbons such as "Teflon" TFE and FEP, etc.

The blending of such materials need not be uniform and the de-hemicellulosed, crosslinked cellulosic may be used as the top or an intermediate layer in a laminated structure; as the centrally located, internal, concentric core or the hollow cylindrical externally positioned, wrapping sheath in a composite tampon construction; or the like.

Other changes, variations, and modifications apparent to a person skilled in the art may be resorted to, without departing from the scope of the present invention which is defined in the following claims.

What is claimed is:

1. A method of making pulpboard for grinding into pulp fluff of improved dry and wet resilience and increased fluid absorption and retention capacity from cellulose fibers having a high hemicellulose content comprising:

treating said cellulose fibers to reduce said hemicellulose content to no more than about 7%;

forming a pulpboard from said treated cellulosic fibers; and

dry crosslinking said fibers in said pulpboard form to result in a pulpboard having a knot content of less than 15%.

2. The method of claim 1 wherein said cellulosic fibers are treated by extracting said hemicellulose with an aqueous solution of from about 5 percent to about 12 percent caustic at a temperature of from about 15° to about 35°C.

3. The method of claim 1 wherein said dry crosslinking is accomplished by introducing said pulpboard to an aqueous bath comprising crosslinking agent and catalyst, driving off the water in a heating step and reacting said crosslinking agent with said cellulose in a curing step.

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CUSTOMER NO. 31013

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Appendix C – Related Proceeding

None